

Work Order ID 53601



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November 9, 2009 1:42:37 PM

Item ID: D3159-043

Accept



Setup Start



Revision ID: C

Stop



Item Name: Bracket Assembly

Start Date: 09/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: BSDate: 09/11/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3159	Rev C								
100		102 Waterjet W	0.00						
		HAAS CNC VERTICAL MACHINING #1							
Waterjet		Memo	0.00						
FLOW CNC Waterjet		CUT AS PER FILE D3159-3/4							
661		DWG REV: <u>E</u>							
663		PROG REV: <u>E</u>							
DEBURR									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

09/11/13

HB 9-11-11

(35)

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Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC8- Inspect parts - second check

0.00

35
counted

10/11/13

QC

Memo

0.00

Quality Control

130



Small Fab

0.00

10/11/13 35

Small Fab

Memo

0.00

Small Fab

1-Deburr break all sharp edges .005 to 0.010□2-C'sink holes as per Dwg D3159

140



NC BRAKE

0.00

35 40

Brake NC

Memo

0.00

Brake NC

1-Form as per drawing (Note: -044 OPPOSITE)

SB 89/11/19

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Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Chemical Conversion Coat per QSI005 4.1

0.00

=> 09/11/19

35

0.00

HandFinish

Memo

Hand Finishing

160



Small Fab

0.00

Small Fab

Memo

Small Fab

Assemble as per dwg.

0.00

170



QC5- Inspect part completeness to step on W/O

0.00

=> 09/11/25

0.00

QC

Quality Control

Memo

Count

x35

f

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Item ID: D3159-043

Accept



Setup Start



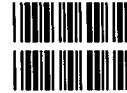
Revision ID: C

Stop



Item Name: Bracket Assembly

Start Date: 09/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: 87

0.00



Packaging

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

18/11/26 30

09/11/26 40

10/11/26
35

Picklist Print

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Work Order ID: 53601



Parent Item: D3159-043RevC



Parent Item Name: Bracket Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD3-13		Purchased		No		100	Each	7,861.000	20.0000		2009/11/23	

QUANTITY
13

M7681

M6061T6S.063



6061-T6 .063 Sheet

Purchased

No

160

sf

216.0499 30.4674

2

13 9-11-11

MS21061L06



Nutplate

Purchased

No

160

Each

129.0000 10.0000



(35)

112939

2009/11/23

ST

129

19085

29

19185

100

14

21

ST

129

19085

29

19185

100

DART AEROSPACE LTD	Work Order:	53601
Description: BRACKET ASSEMBLY	Part Number:	D3159-3
Inspection Dwg: D3159-3 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB
Date:	9-11-11

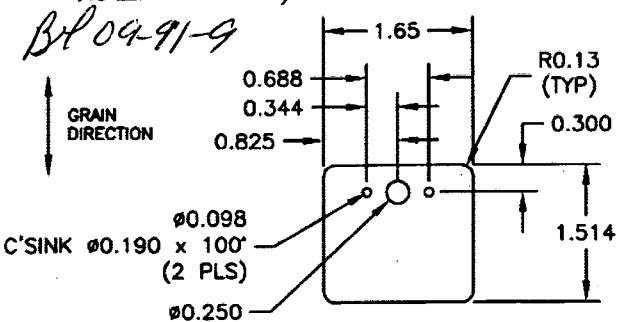
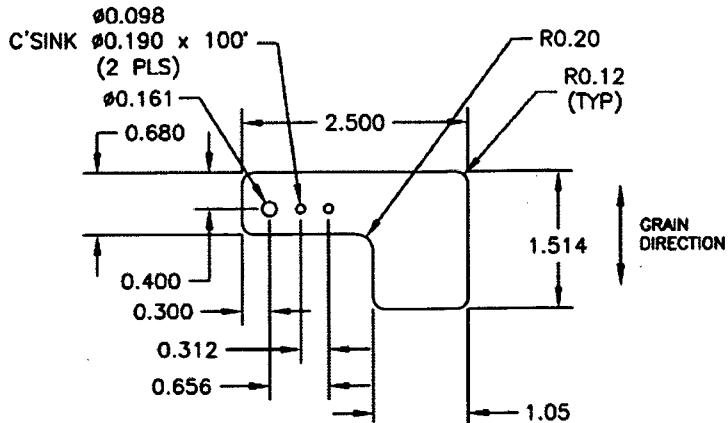
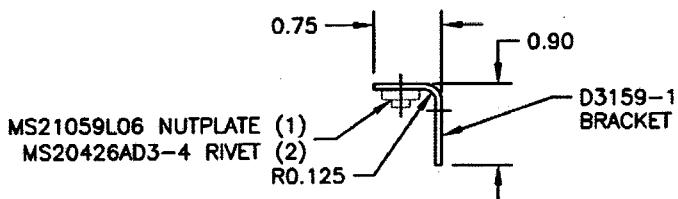
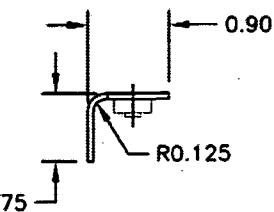
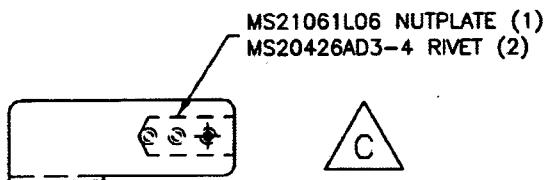
Audited by: _____
Date: 64-11-13

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	P10D3159-043	Revised by	Approved
A		New Issue		KJ/JLM	

DARTSHOP COPY
RETURN TO
ENGINEERING

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3159	REV. C SHEET 1 OF 1
DATE 05.11.21		TITLE BRACKET ASSEMBLY	SCALE 1:2

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53001**D3159-1F FLAT PATTERN**
(USED TO MAKE D3159-1 BRACKET)**D3159-3F FLAT PATTERN**
(USED TO MAKE D3159-3/-4 BRACKETS)**D3159-041 BRACKET ASSEMBLY****D3159-043 BRACKET ASSEMBLY (SHOWN)**
REPLACES PREMIER P/N B30-23000-259
(D3159-044 BRACKET ASSEMBLY (OPPOSITE)).
REPLACES PREMIER P/N B30-23000-260**RELEASED**
05.12.01**NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY D3159-041/-043/-044 WITH DART P/N USING FINE POINT PERMANENT INK MARKER